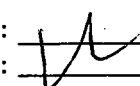
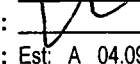


Date: Thursday, 10/08/2006 9:56:35 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 28113		
Estimate Number	: 10420		
P.O. Number	: N/A	Part Number	: D3303043
This Issue	: 10/08/2006 S.O. No. : N/A	Drawing Number	: D3303 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 27569	Material	: N/A
Written By	: 	Due Date	: 21/08/2006
Checked & Approved By	: 	Qty:	5
Comment	: Est: A 04.09.07 New Issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D33031	Plate
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) PLATE Pick: Qty Part Number Description Batch 1 D3303-1 Plate B 27649		
2.0	D33033	Bracket
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) BRACKET Pick: Qty Part Number Description Batch 1 D3303-3 Bracket B 29200		
3.0	MS20426AD33	Rivet
		
Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 8 MS20426AD3-3 Rivet M 19090		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:56:35 AM
User: Linda LaCelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28113

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description
16	MS20470AD4-4	Rivet

Batch

M102328

FF 06-11-23

5

5.0

MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nutplate

Pick:

Qty	Part Number	Description
4	MS21075L3	Nut Plate

Batch

M18534

FF 06-11-23

5

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D3303

2- Identify as D3303-043

FF 06-11-23

5

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/23 (5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

****MASK THREADS PRIOR TO PAINT****

q.m. JL 06/12/02 x5

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/14/05 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57922

06/22/05 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DB Date: 06/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:56:35 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28113

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

⑤
P 06/12/05

Job Completion



h 06/17/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

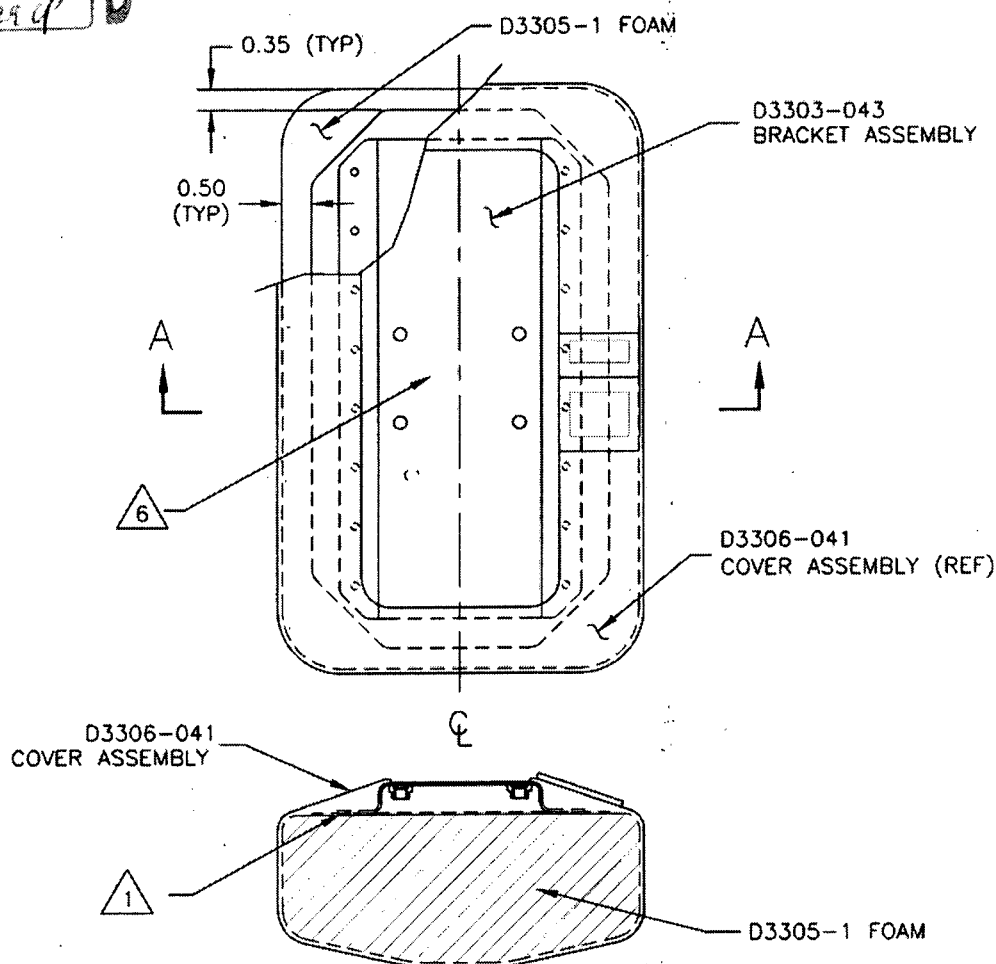
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3303 REV. A SHEET 1 OF 4
DATE	04.08.18	TITLE	HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE		

RELEASED
04.09.29 *CP***SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

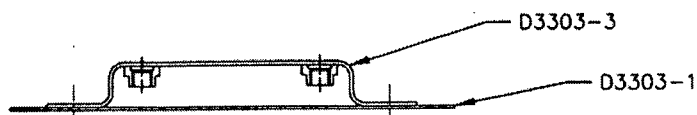
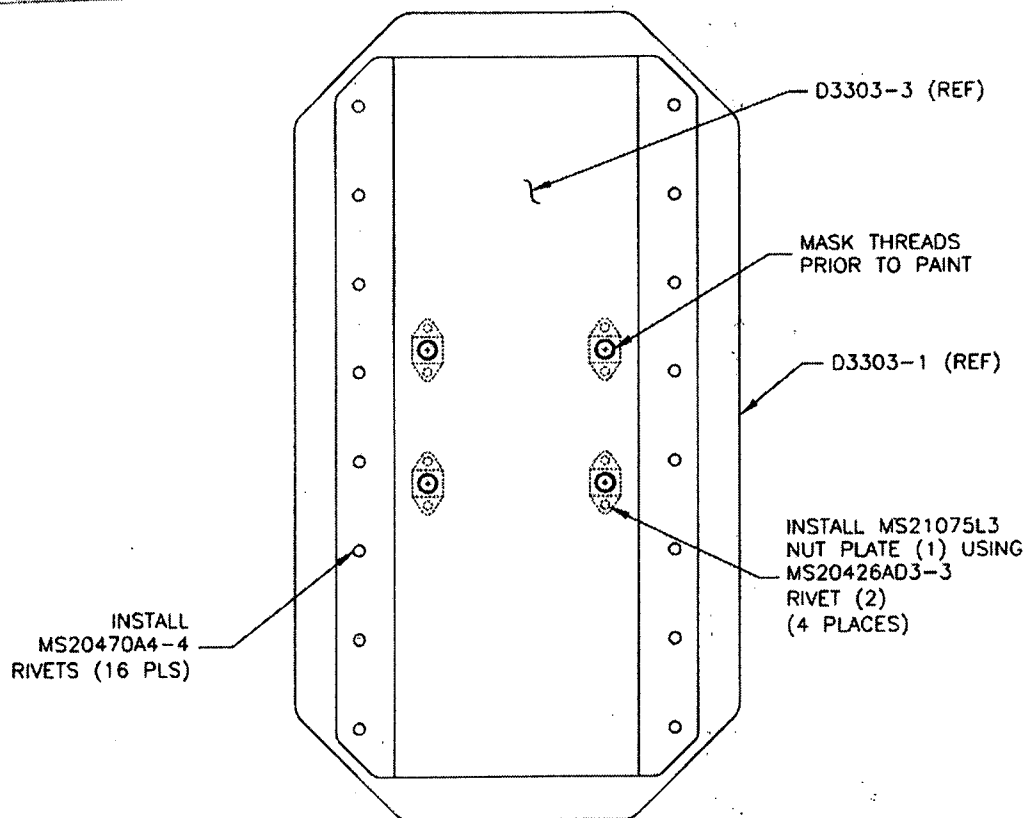
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3303	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

RELEASED
09.09.29 GP



D3303-043 BRACKET ASSEMBLY

D3303-043 NOTES:

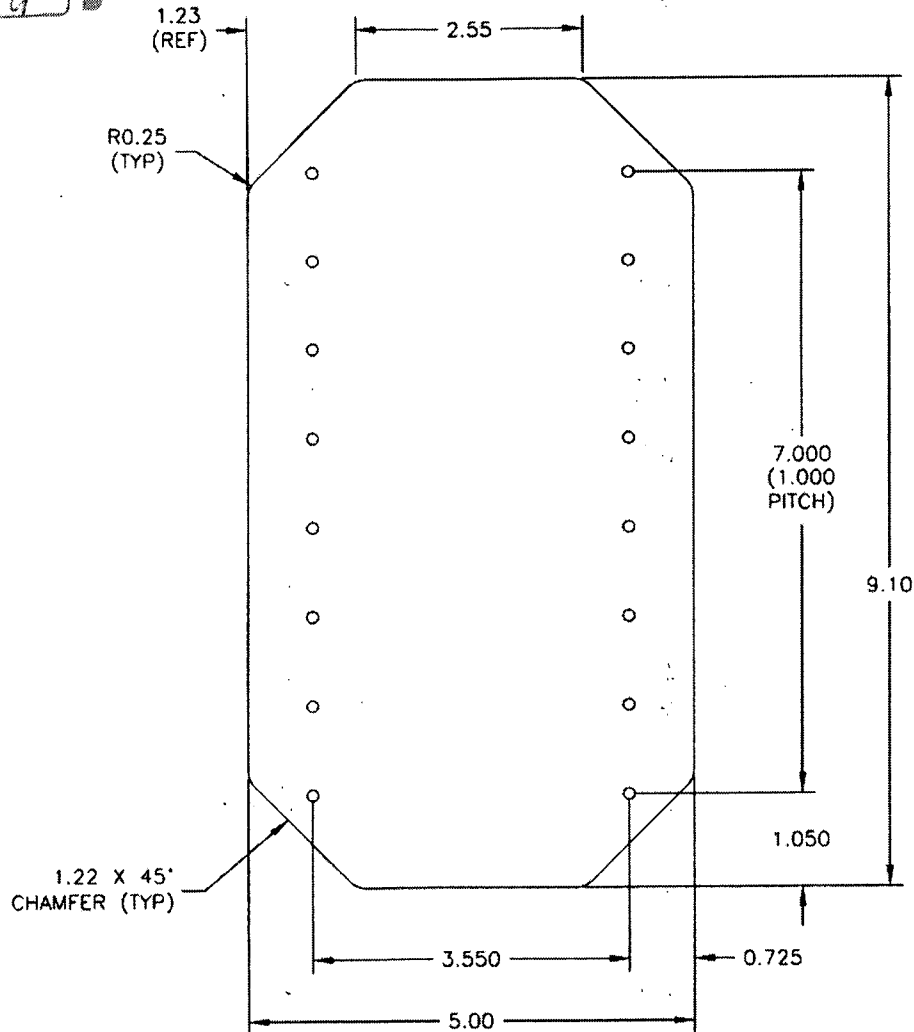
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 3 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

RELEASED
04.09.29 *[Signature]***D3303-1 PLATE****D3303-1 NOTES:**

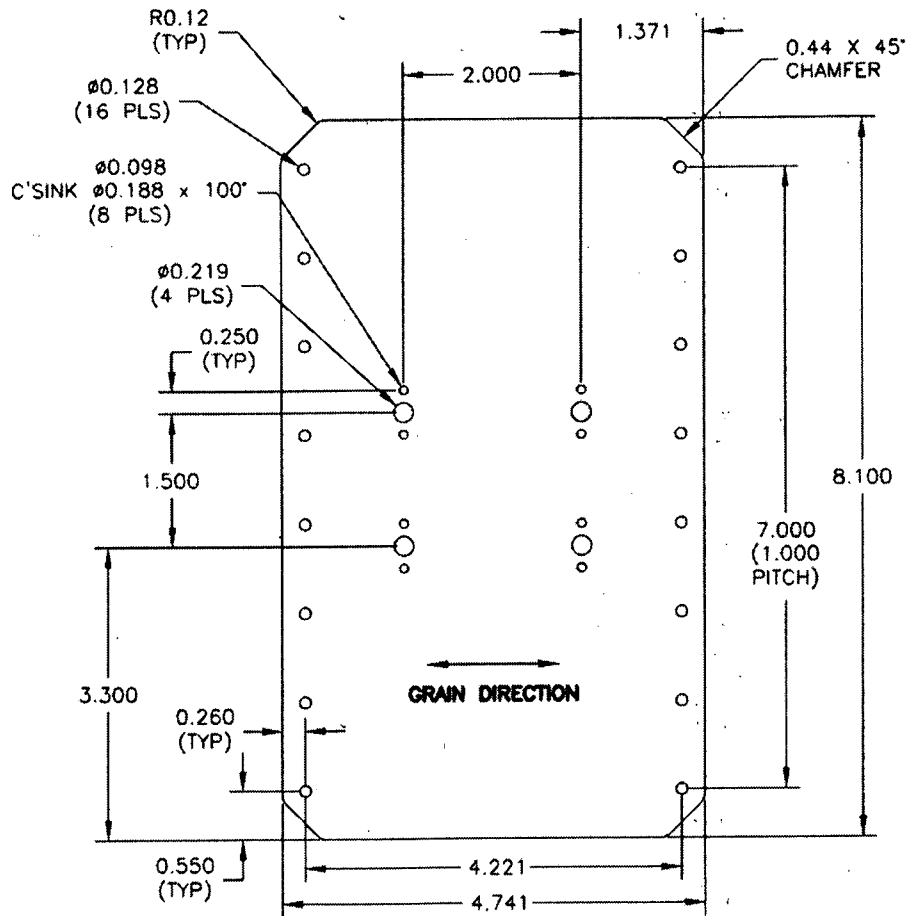
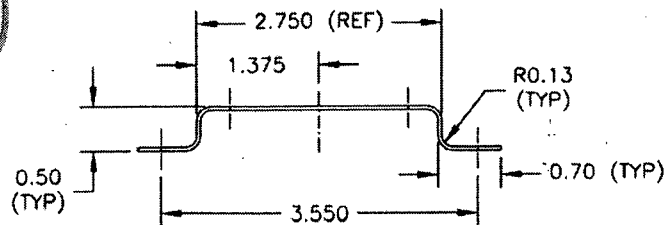
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18	TITLE HEAD REST		SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**
09.09.29 CP**D3303-3 BRACKET
BEND DETAIL****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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